

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006376**Date Inspected:** 10-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xiao Yun, Chen Chen, Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SAW welding of weld joint WSD1-FBSA3-2A/C-13A located on PCMK west tower, lift 3, skin B. Welder was identified as 202756. ZPMC QC was identified as Xiao Yun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Fitting and SMAW tack welding of weld joint WSD1-FDSA3-2B/C-19 located on PCMK west tower, lift 3, skin D. Welder was identified as 205678. ZPMC QC was identified as Chen Chen (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2211-B-U3b.

Bay 9 - PMT

This QA Inspector, George Goulet, was in Bay 9 to monitor OBG Production Monitoring Test (PMT) #1 for deck panels DP349-002 and DP133-002 at Gantry #2. Prior to PMT #1, the magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Cai Xin Xin. The visual inspection of tack welds and root gap was performed by ABF Representative Huang Wen Guang (ABF), ZPMC CWI Li Jia (QC3), and this QA Inspector, George Goulet. At approximately 0100 hours, QC3 informed this QA Inspector, George Goulet, that ZPMC would not be performing the PMT noted above until after 0700 hours because of mechanical problems with some of the welding equipment on the gantry.

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Summary of Conversations:

As noted above, and this QA Inspector, George Goulet, asked each QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector, George Goulet, that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
